

Date: Thursday, 13/11/2008 11:03:25 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE  
 Job Number : 43427 -2  
 Estimate Number : 10606  
 P.O. Number :  
 This Issue : 13/11/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL /MED FAB  
 Previous Run : 41939  
 Part Number : D33193  
 Drawing Number : D3319 REV. B  
 Project Number : N/A  
 Drawing Revision : B  
 Material :  
 Due Date : 20/11/2008 Qty: 12 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est: A 05.05.12 New issue KJ/JLM  
 Est Rev:B Now on Waterjet 06-10-03 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S18GA 1010/1025 SHEET .048



Comment: Qty.: 3.4150 sf(s)/Unit Total : 40.9802 sf(s)

1010/1025/A21/6aA SHEET .048" Thick

Batch: 109948 HB 8-11-19

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3319

Dwg Rev: B HB 8-11-19

Prog Rev: B

2-Deburr if necessary HB 8-11-19

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

Done at ser # 2.2  
 8/11/19

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 43427

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form using DT8326 & DT8261 as per Dwg D3319 Rev: 6

08/11/20

(13)  
(12)  
(13)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

09/11/20

(12)  
(13)  
SP/17

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: B

Qty Part Number Description Batch  
A/R N/A 7560 Hardcoat Rod

M109560

EL 8-11-21

(12)

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/11/21

(12)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/11/21

(12)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1=00  
320°  
1=30

08/11/21

(12x)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08/11/21

(12x)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:  
TCCA-PDA, Dart Aerospace Ltd.

08/11/21

(12x)  
SP



Date: Thursday, 12/11/2008 11:03:26 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 43427

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

P/N: D3319-3, B/N: BXXXXX  
For Product Eligibility see PDA05-18  
and Stock  
Location: 497

8/11/21

12\* 50

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-21

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

HAWKESBURY, ONTARIO, CANADA

REV. B

SHEET 1 OF 5

SCALE

05.06.06

## EARPLATE

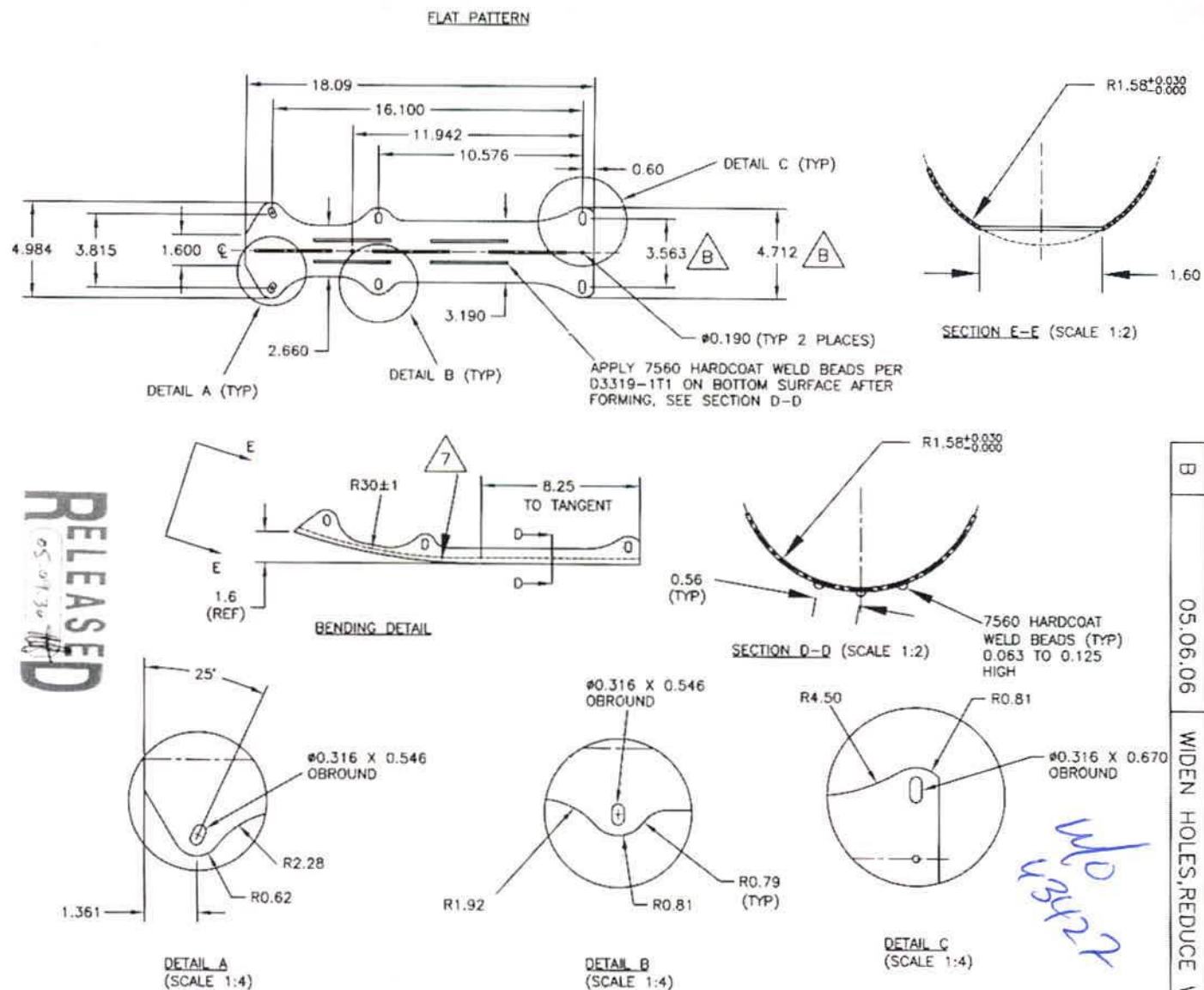
1:8

A

NEW ISSUE

4

WIDEN HOLES,REDUCE WIDTH -3/-5/-7



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)  
2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) PART IS SYMMETRICAL ABOUT CENTERLINE  
5) ALL DIMENSIONS IN INCHES  
6) WELD PER DART QSI 004  
7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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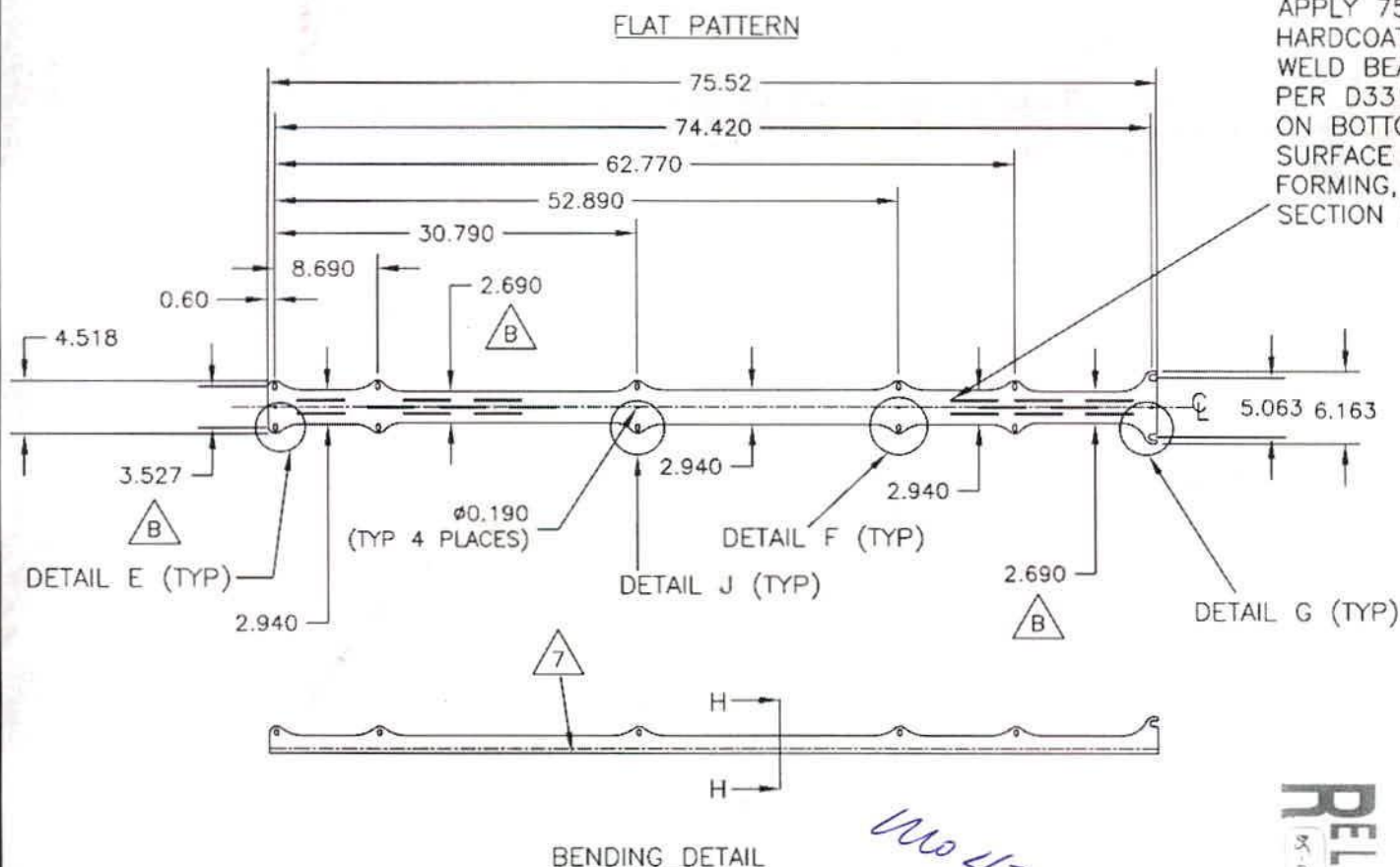
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05-07-30  
161

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>GH</i>	APPROVED <i>GH</i>	HAMKESBURY, ONTARIO, CANADA
DATE 05.06.06	TITLE WEARPLATE	REV. B
	DRAWING NO. D3319	SHEET 2 OF 5
	SCALE 1:15	

APPLY 7560  
HARDCOAT  
WELD BEADS  
PER D3319-3T1  
ON BOTTOM  
SURFACE AFTER  
FORMING, SEE  
SECTION H-H



#### D3319-3 WEARPLATE

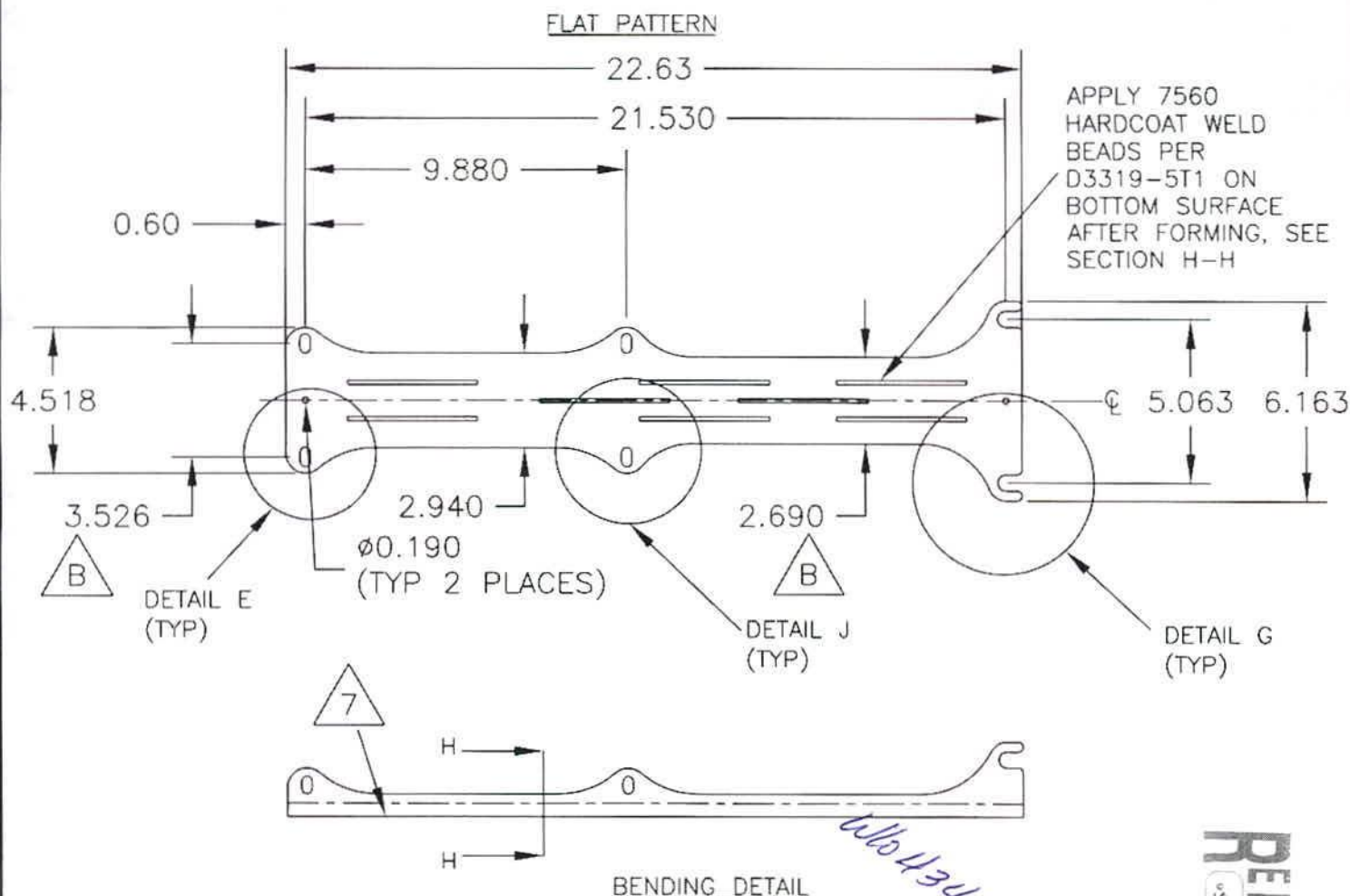
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- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED  
EX-0130



**DART**

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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	DRAWING NO.	D3319	REV. B
		TITLE	WEARPLATE	SHEET 3 OF 5
				SCALE 1:5

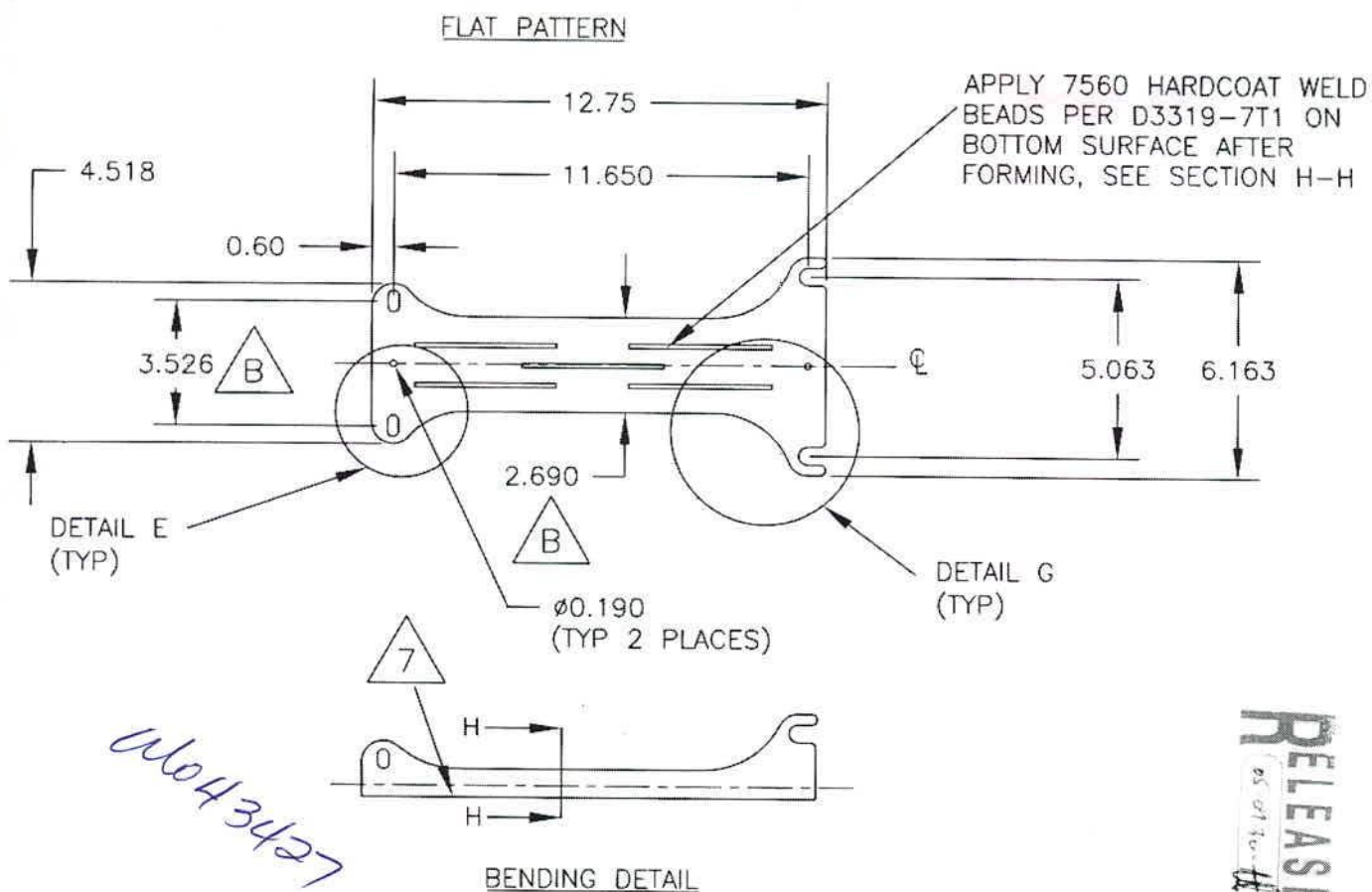


#### D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D3319
DATE	05.06.06			TITLE	WEARPLATE
				REV. B	SHEET 4 OF 5
				SCALE	1:5



D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,  
38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,  
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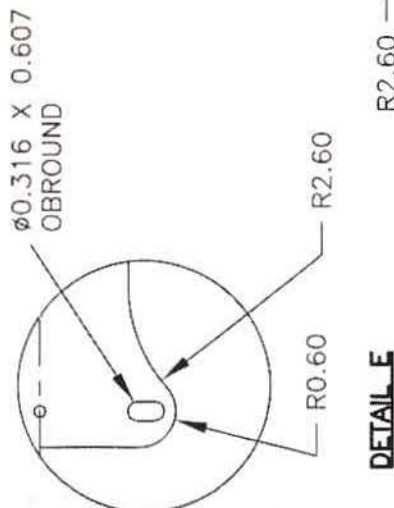
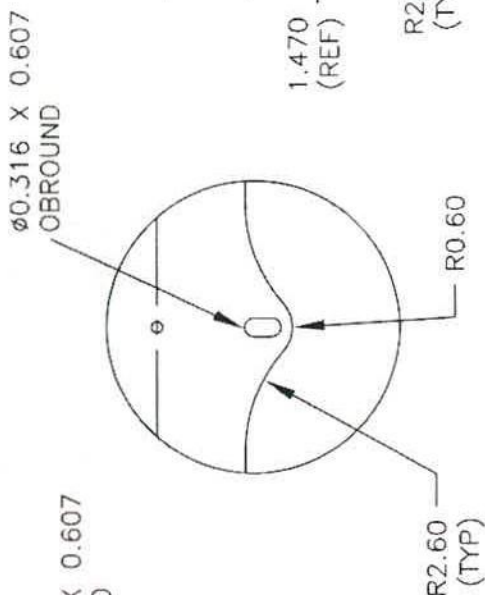
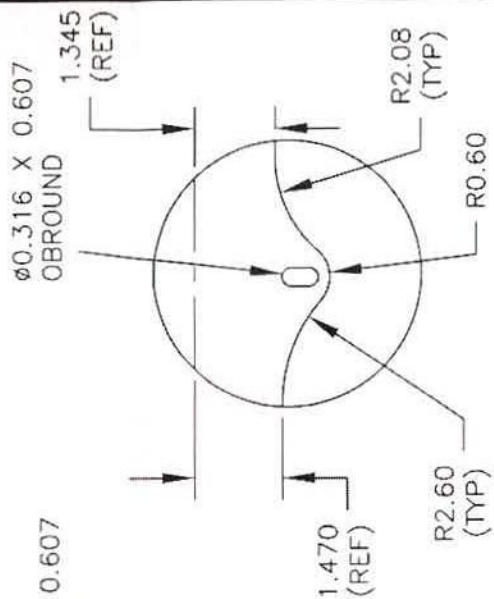
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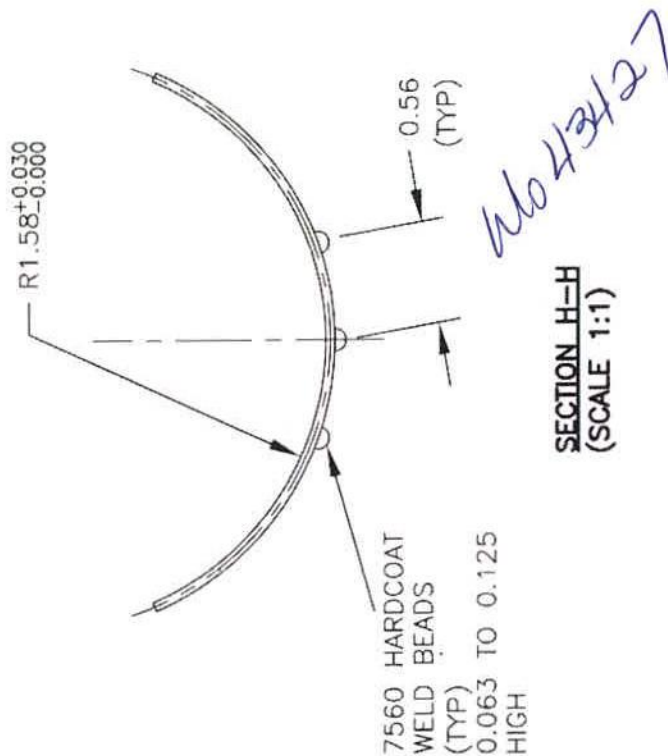
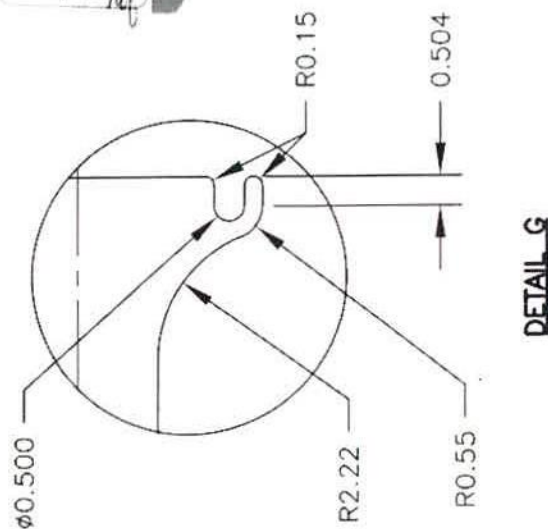


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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06	TITLE WEARPLATE		SCALE 1:3



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05 09 30



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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43421
<b>Description:</b> WEAR PLATE		<b>Part Number:</b> D3319-3
<b>Inspection Dwg:</b> D3319-3 <b>Rev:</b> B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
190	+0.05 - .001	194	✓			
316	± .010	320	✗			
<del>316</del>	± .010					
.607	± .010	6.11	✗			
2.940	± .010	2.944	✗			
2.690	± .010	2.696	✗			
3.527	± .010	3.528	✓			
4.518	± .010	4.516	✓			
.60	± .030	.601	✗			
5.063	± .010	5.065	✗			
6.163	± .010	6.165	✗			
8.690	± .010	8.688	✗			
30.790	± .010	30.790	✓			
52.890	± .010	52.890	✗			
62.770	± .010	62.770	✗			
74.420	± .010	74.420	✗			
75.52	± .030	75.52	✗			
.048	± .010	.046	✗			

<b>Measured by:</b> RB
<b>Date:</b> 8-11-19

<b>Audited by:</b> S
<b>Date:</b> 08/11/19

<b>Prototype Approval:</b> n
<b>Date:</b> 1/19

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	